

OCT 1 1985

Docket No. 50-461

Illinois Power Company  
ATTN: Mr. W. C. Gerstner  
Executive Vice President  
500 South 27th Street  
Decatur, IL 62525

Gentlemen:

In NRC Inspection Report No. 50-461/85032, the Region III inspection of allegation RIII-85-A-0116 dealing with socket weld fitup is documented. Two items of concern were left as one unresolved item (461/85032-02). Since then the NRC has received additional information and concerns from the allexer. The information is paraphrased in the attached enclosure and is forwarded to Illinois Power Company for review and followup.

We request that the results of your review and disposition of this matter be submitted to Region III after completion. Documentation supporting your results should be maintained onsite for audit by Region III.

Your cooperation with us is appreciated. Should you have any questions with regard to this matter, please call Mr. R. F. Warnick (312) 790-5575.

Sincerely,

"Original Signed By C.E. Norelius"

Charles E. Norelius, Director  
Division of Reactor Projects

Enclosure: Additional Information and  
Concerns Regarding Allegation  
RIII-85-A-0116

cc w/enclosure:  
DCS/RSB (RIDS)  
Licensing Fee Management Branch  
Resident Inspector, RIII  
Richard Hubbard  
Gary N. Wright, Manager  
Nuclear Facility Safety  
Jean Foy, Prairie Alliance  
Allen Samelson, Assistant  
Attorney General,  
Environmental Control Division  
H. S. Taylor, Quality Assurance  
Division

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G PDR

RIII  
P2H for  
Warnick/rl  
9/20/85

YCS  
RIII  
Weil  
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#cceduro 9/27/85

RIII  
Greenman  
9/30/85

RIII  
Norelius  
9/1/85  
10/1/85

RIII  
Harrison  
9/27/85

1/1 IED1  
DMB

ENCLOSURE

Additional Information and Concerns Received from the Allegor Regarding Allegation RIII-85-A-0116

1. It is possible that many instrumentation lines are almost closed with "sugar." A thorough flush could not take place. The welding procedure used to weld "Cajon" fittings to .065" wall instrumentation tubing, NP-8-8-BS, was defective. It is not possible to make consistently good welds on this wall thickness using the minimum requirements of this procedure, i.e., 300°F maximum interpass temperature, 50 amps minimum, and no internal purge.
2. Acceptable welds were produced by making the welds in tacks about 1/4" long and cooling with water mist to ambient temperature between tacks. This method was not used for the bulk of field welding on this material at Clinton.
3. Radiographs of welds 1-IS-912-4, 1-CM-905-92Q1, 1-CM-905-2Q1, 1-CM-905-91, and 1-SM-906-5Q2 revealed severe burn-through and internal restrictions.
4. Minimum wall thickness violations may exist. Training given inspectors on the use of D-meters would result in inaccurate readings (readings that would indicate the material was thicker than actual). The training was not modified after this problem was brought to the attention of BA.